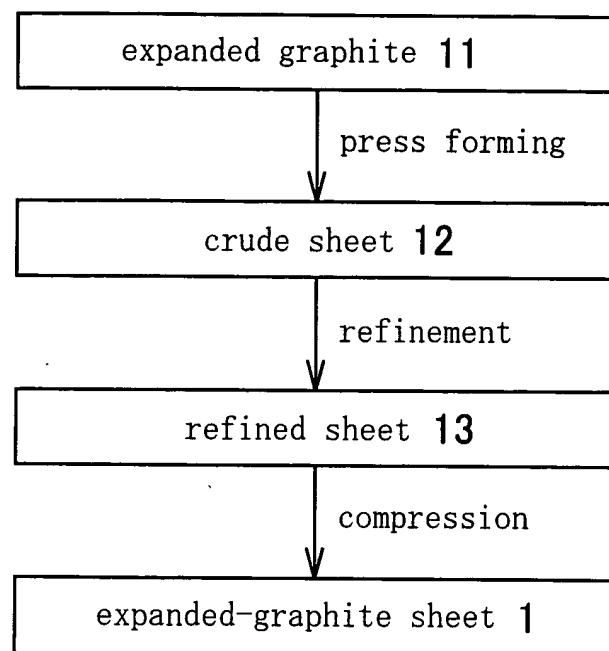
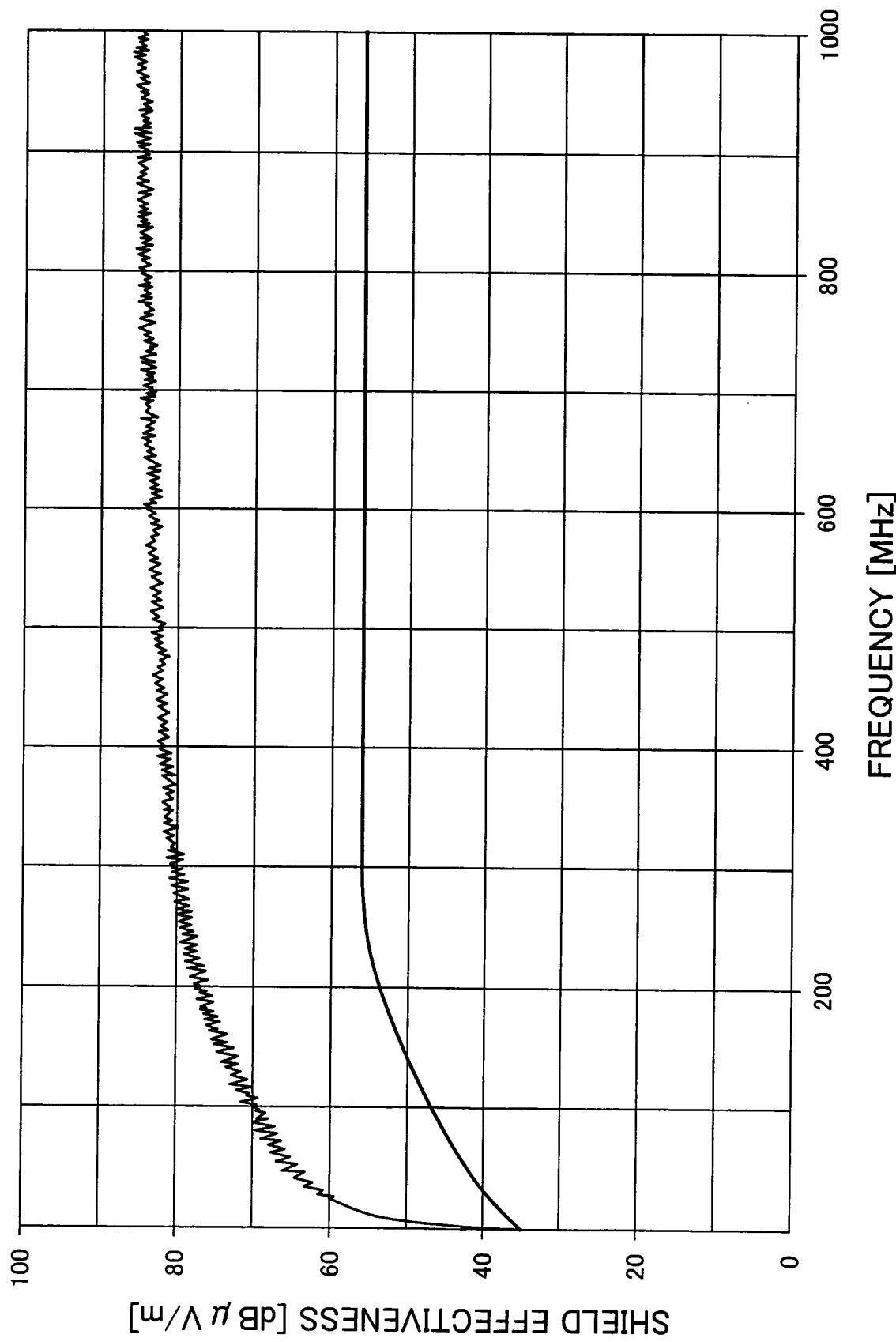


1/3
F I G. 1



2/3
F I G. 2

F I G. 3
3/3

		rolling speed (m/min)					
		1	2	4	6	8	10
creases	no creases	no creases	creases	creases	creases	creases	creases
	surface roughness	2	3	5	6	6	6
inter line average height Ra (μ m)							
Max-Min Ave	5	8	14	14	22	30	
$\times 100$ (%)							